

Process Sheet

Additional Product

Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPDSI9367-011

4
K-8 07.03.22

20 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D35641	WEARSHOE
-----	--------	----------

[illegible]

Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

WEARSHOE

Batch: D3/L3d ✓

4.0	D35661	GASKET
-----	--------	--------

[illegible]

Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

GASKET

Batch: D.31133

50	D35643	WEARSHOE
----	--------	----------

[illegible]

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

WEARSHOE,

Batch: D31139

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 3:47:53 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SS WEARSHOE KITS

Job Number: 31415

Part Number: DSI9367011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
WEARSHOE
Batch: B31136 ✓ ✓

7.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
GASKET
Batch: B31135 ✓ ✓

8.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 96.0000 Each(s)
BOLT
Batch: M103691 ✓

9.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)
BOLT
Batch: M103693 ✓ ✓

10.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)
BOLT
Batch: M103668 ✓ ✓

11.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 176.0000 Each(s)
washer
Batch: M102602 ✓ ✓

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Handwritten signatures and dates:
✓ 04/04/02 (4)
07/14/04 (4) 07/09/04 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/21/2007 3:47:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SS WEARSHOE KITS

Job Number: 31415

Part Number: DSI9367011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Dsi9367-011

Location:

PPP Rev:

DART

6/7/4

Q

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107/04/05 *(4)*

Job Completion



u 5/10/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9367	REV. A SHEET 1 OF 3
DATE 07.02.09		TITLE STAINLESS STEEL WEARSHOE KITS	SCALE NTS
A	07.02.09	NEW ISSUE	

DART SERVICE INSTRUCTION
TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. B
REF. FAA STC: SR01583SE
REF. CANADIAN STC: SH05-37 ISSUE 1

For customers with D412-742-011/-013 float skid tubes at CHG 002 or earlier who would like to upgrade to stainless steel wearshoes the following kit can be obtained from Dart:

QTY -011	Part Number	Description
X	DSI 9367-011	WEARSHOE KIT
1	D3564-1	WEARSHOE (REPLACES D3460-1)
2	D3566-1	GASKET
1	D3564-3	WEARSHOE (REPLACES D3460-3)
1	D3564-5	WEARSHOE (REPLACES D2577-5)
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

For customers with D412-742-011/-013 float skid tubes at CHG 002 or earlier who would like to upgrade the fwd and aft sections of their float skid tubes, the following kits can be obtained from Dart:

QTY -013	Part Number	Description
X	DSI 9367-013	WEARSHOE KIT
1	D3564-13	WEARSHOE
1	D3566-13	GASKET
1	D3537-1	WEARPAD
1	D3553-1	GASKET
1	D3537-7	WEARPAD
1	D3553-3	GASKET
10	NAS1330C3KB166	INSERT
4	NAS1330C3KB266	INSERT
10	AN3C4A	BOLT
4	AN3C5A	BOLT
14	AN960C10L	WASHER

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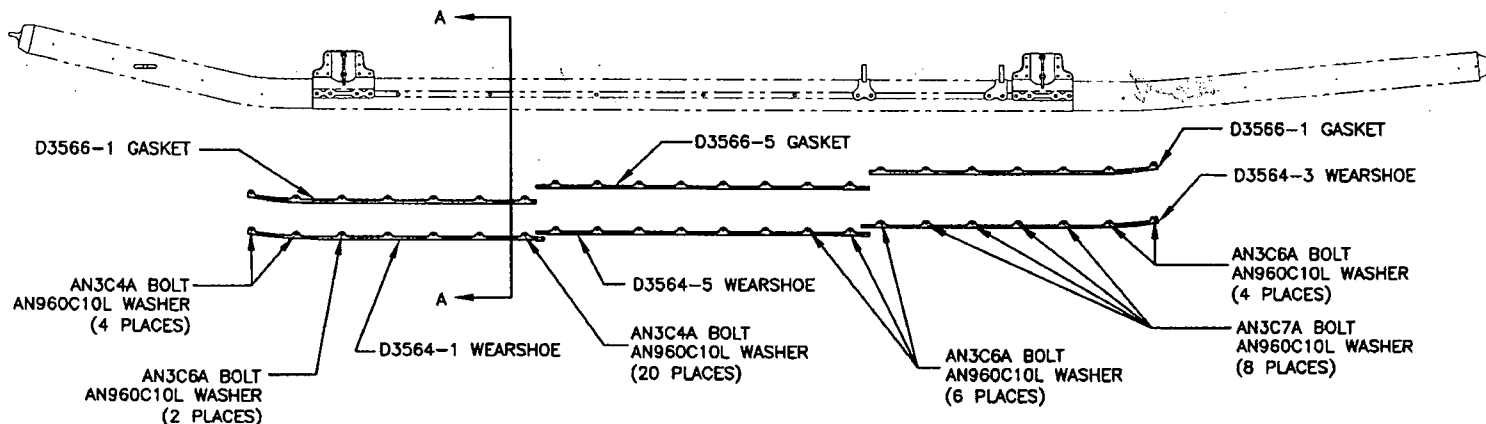
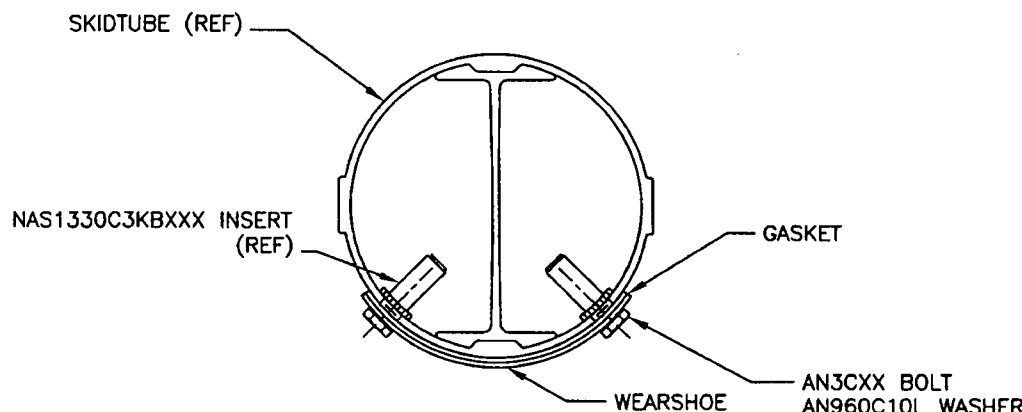


FIGURE 1: DSI 9367-011 WEARSHOE KIT



**SECTION A-A
(TYPICAL INSTALLATION)**

DSI 9367-011 Wearshoe Kit Installation Procedure

- 1) Remove skidtube from aircraft per Section 32.1 of ICA-D412-742.
- 2) Remove existing D3460-1/-3 and D2577-5 wearshoes by removing AN3C hardware. Begin wearshoe removal from the fwd end of the skidtube towards the aft end.
Note: Removing the wearshoes will require breaking a layer of sealant between the wearplates and the skidtube.
 Clean residual sealant off the bottom of the skidtube. Check for corrosion and mechanical damage in accordance with Chapter 5 of ICA-D412-742 and repair as required.
- 3) Install D3564-1/-3/-5 wearshoes complete with D3566-1/-5 gaskets using AN3C bolts beginning from the aft end of the skidtube and install towards the fwd end of the skidtube as shown in Figure 1. Seal all bolts with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing. Torque bolts to 15-25 in-lbs (1.7-2.8 N-m).
- 5) Re-install skidtube on aircraft per Section 32.2 of ICA-D412-742.

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DATE	07.02.09	DRAWING NO.	DSI 9367	REV. A
		TITLE	STAINLESS STEEL WEARSHOE KITS	SHEET 2 OF 3
				SCALE
				NTS

DART

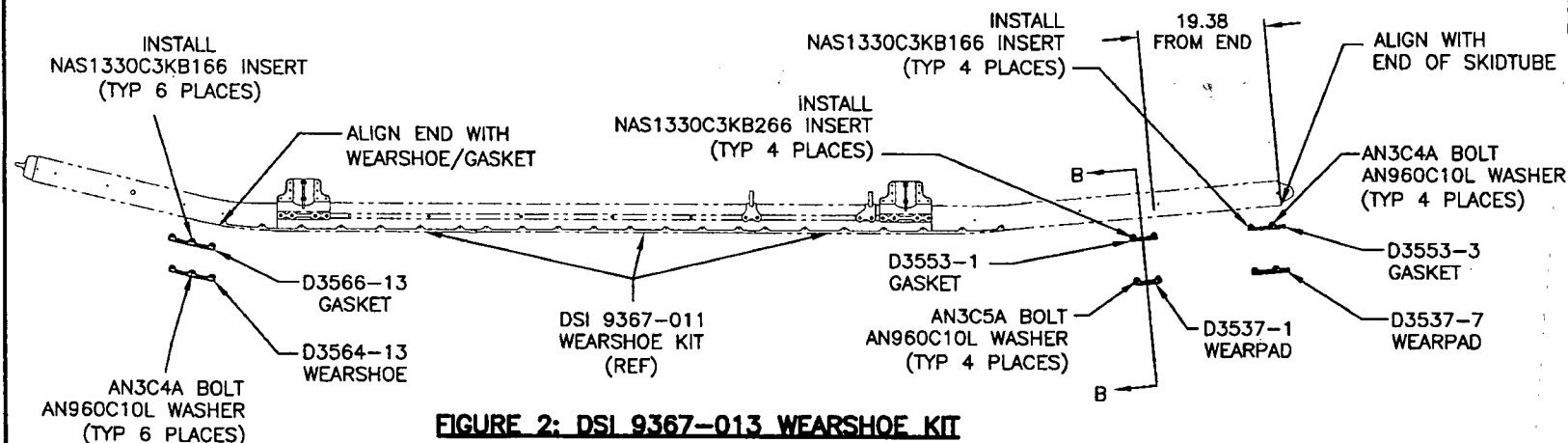
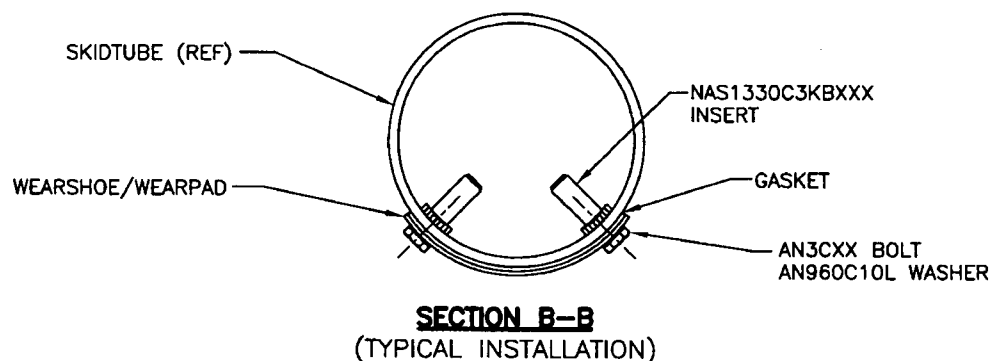


FIGURE 2: DSI 9367-013 WEARSHOE KIT



SECTION B-B
(TYPICAL INSTALLATION)

DSI 9367-013 Wearshoe Kit Installation Procedure

- 1) Remove skidtube from aircraft per Section 32.1 of ICA-D412-742.
- 2) Check skidtube for corrosion and mechanical damage in accordance with Chapter 5 of ICA-D412-742 and repair as required.
- 3) Locate the wearshoe/wearpads and gaskets as shown in Figure 2.
- 4) Using the wearshoe/wearpad/gasket as a template, drill $\varnothing 0.125$ " holes in the center of the wearshoe/wearpad obrounds. Remove the wearshoe/wearpad/gasket and drill qty (14) $\varnothing 0.250$ " - $\varnothing 0.257$ " holes for installing the required inserts, countersink all holes to $\varnothing 0.391 \times 100^\circ$. Deburr and remove swarf from inside of skidtube. Touch up holes with chemical film material (Alodine 1200/1201) per MIL-C-5541 and one coat of MIL-P-85582 or MIL-P-23377 primer. Install NAS1330C3KB inserts using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant prior to installation. Install D3564-13 wearshoes and D3537-1/-7 wearpads complete with D3566-13 and D3553-1/-3 gaskets using AN3C bolts as applicable. All bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing. Torque bolts 15-25 in-lbs (1.7-2.8 N-m).
- 7) Re-install skidtube on aircraft per Section 32.2 of ICA-D412-742.

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. DSI 9367
DATE	07.02.09	TITLE	STAINLESS STEEL WEARSHOE KITS	REV. A SHEET 3 OF 3
		SCALE	NTS	

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